

ASAP Geneva

Dart Aerospace Ltd.

Date: Friday, 19/01/2007 8:50:49 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DND001 Department of National	Drawing Name	: STIFFENER
Job Number	: 30331		
Estimate Number	: 12659		
P.O. Number	: N/A	Part Number	: G106102
This Issue	: 19/01/2007 S.O. No. : N/A	Drawing Number	: G10610 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL / MED FAB	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: _____	Due Date	: 26/01/2007 Qty: 10 Um: Each
Checked & Approved By	: _____		
Comment	: Est Rev:A New Issue 07-01-18 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1510 sf(s)/Unit Total: 1.5100 sf(s)

2024-T3 .040 sheet

Batch: M102448 (20)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg G10610

Dwg Rev: 106102

Prog Rev: A

SAB 07/01/22

(10)

2-Deburr if necessary

****USE SAME CUTTING FILE FOR -1 & -2****

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

M 07/01/23

(10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

SB John 07/01/22

16

Date: Friday, 19/01/2007 8:50:50 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DND001 Department of National

Drawing Name: STIFFENER

Job Number: 30331

Part Number: G106102

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Formas per Dwg G10610

SB 07/01/25 (10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/23 10

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

23/48 07/01/24 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/01/24 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/01/24 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/30

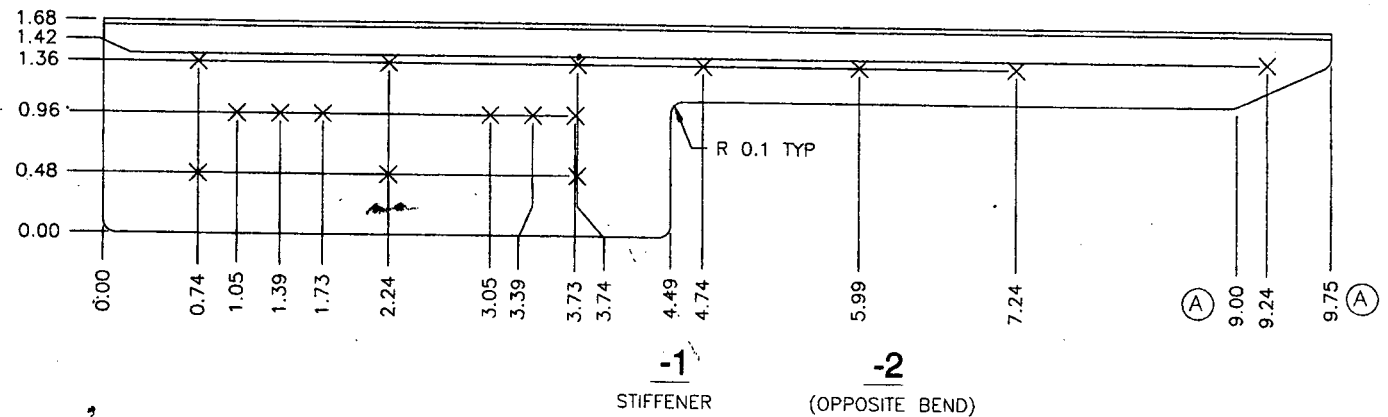
Job Completion



07-01-30

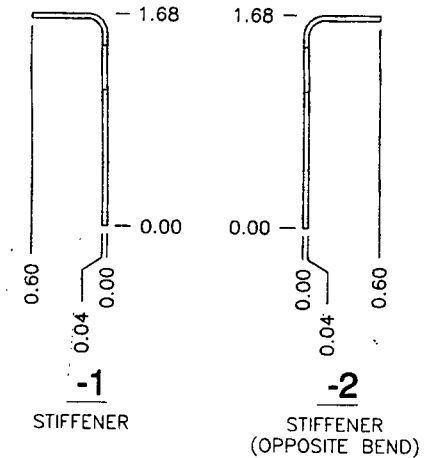
W/030331

REVISION			
REV	DESCRIPTION	DATE	APPROV.
A	9.75 WAS 8.98, 9.00 WAS 8.25, ADDED MATERIAL CALLOUT FOR -3	4/8/01	CLB



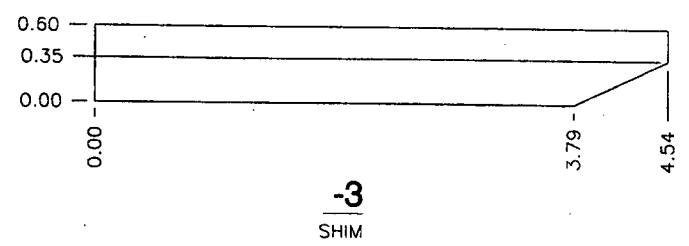
-1
STIFFENER

-2
(OPPOSITE BEND)

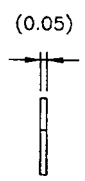


-1
STIFFENER

-2
STIFFENER (OPPOSITE BEND)




-3
SHIM



NOTES:

UNLESS OTHERWISE NOTED.

- MAT'L:
 (A) -1 ALUM, 0.04 THICK, 2024-T4 AU4G1.
 -2 ALUM, 0.04 THICK, 2024-T4 AU4G1.
 -3 ALUM, 0.05 THICK, 2024-T4 AU4G1.
- INSIDE BEND RADIUS: 3T, 90°±5'.
- FINISH: ETCH, ALODINE PER MIL C5541-1A, PAINT WITH ACRYLIC URETHANE.
- ALL HOLE LOCATIONS ARE RECOMMENDED REFERENCE ONLY. FINAL LOCATIONS TO BE DETERMINED AT INSTALLATION. MATCH DRILL PARTS AT ASSEMBLY.

BREAK ALL EDGES ✓ UNLESS OTHERWISE SPECIFIED DIMENSION ARE IN INCHES DIMENSIONAL TOLERANCES 3 DECIMALS ± 2 DECIMALS ± .020 1 DECIMAL ± .050 ANGULAR ± 1°	DRAWN	DT	DATE	 GENEVA AVIATION 10108 - 32nd Ave W Everett, WA 98204 (425)353-7400 FAX(425)347-7100
	CHECK		DATE	
	DESIGN		DATE	
	APPROVAL	DCF	DATE	
THIS DRAWING INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION INC.				TITLE REAR SHOULDER HARNESS INSTALLATION MODIFICATION
DWG NO. G10610				REV. A
PRO NO. GA159 SIZE B SCALE 1/1				SHT. 1 OF 2

VPK METAL
DART AEROSPACE
 ALUMINUM SHEET 2024 -T3
 .0400 Nom X 48.0000" X 144.0000"
 PART NO.

PO/Rel PO00002219

We certify that this is a true copy of the report
 furnished by the producer of the metal, or data
 resulting from tests made in approved labs.

Signed by: _____

Attn: _____

Certificate of Mill Test Results

BL PEC-432265-001

19Oct06

Pg 1/2

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From:

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
 Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
 Quality Assurance Manager

617430

0

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

Page 1

2006-05-30

1503480

00000

1881283-1

P.O. No./Govt Contract No.

Customer Mfg Order

CJ3347

C&B

DS-81283-1

Ship To: COPPER BRASS SALES
 1715 WOODLAND DRIVE
 SALINE, MI 48176

Item Description

0.0400 IN TK X 48.000 IN W X 144.000 IN LN CAT D 126137 (N) A/T 2024-
 T3 (FLAT) SHEET MILL FINISH ((P/N 061825-6)) PER AMS-QQ-A-
 250/4 REV A & (EX. OIL&MARK)
 AMS4037 REV N & (EX. MARK) ASTM B209 REV 04
 ((MARKED)) INTERLEAVED MAX GROSS
 SKID WGT: 4500 LB QUAN TOL +/-30 %
 CQR D126137 REV 22 CUST REQ 06-05-
 28 *** W/E 06-06-03 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	383823	718351	3902	142	PC	

Notes for CQR: D126137.22

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDMENT 2.
 PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/4.

CQR: D126137.22 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
T3	Long Transv.	KSI	KSI	PCT
	Max			
	Min	63.0	42.0	15

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
Alloy 2024	.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15
	Max									
	Min			3.8	.30	1.2				REMAIN

Lot: 718351 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No. Test	UTS	TYS	EL4D
T3	Long Transv.	6	KSI	KSI	PCT
	Max		67.6	45.5	20.2
	Min		66.9	44.6	18.5

G10610-2 B 30331